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Memo

OC

Quality Control

NCR: Y	es / No	İ			WORK ORDER NON-	CONFC	JKN	HANCE / UP	DATE	QA Closed:	Date	•
					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er:	1			Rework	7		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raitiv	····	<u> </u>			Use-as-is	<sub>Th</sub>		noforming	Finishing	<b>⊣</b>	re/Packaging	Other
NCR N	lo	<u> </u>			Work Order Update	]   ''		Large Fab	Composite		Supplier	
Root		1		Descri	ption of work order update	Initia	al	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief I	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1										
quip/Tooling							ļ					
Operator												
Material											[	
Setup	_	il										
Other	_	!]				1						
Process	_		·								ļ	
Supplier	_					•			•			
Training	_					ŀ						
Jnapproved		<u> </u>	<u> </u>			<u> </u>					<u> </u>	
						AULT C	ATEC	GORY				
Landin F	ng Gear			_	General	г1_			_	٦		٦
-	Bending				Bend	Gra			<u> </u> -	Ovalized	<b>-</b>	Pressure/Forced
		lot Conce	ntric to	<sup>O/S</sup>  -	BOM/Route	<b>—</b> —	dwa			Over/Under	<b>⊢</b>	Temperature/Cure
}	Cracks	<i>(</i> - :			Broken/Damaged	-		on Incomplete	<u> </u>	Part Incorre	<del>-</del>	Weld '
}	<b>—</b> 1	ed/Crimped. Burrs				$\vdash$		ions Incomplete/	Unclear	Part Lost/M	_	Wrong Stock Pulled
}	Cuffs			_	Contamination	<del></del>		nance	<u> </u> -	Part Moved		
	Heat Tre		<b>T</b> .b		Countersink	<b>⊢</b>	labe		<u> </u>	Positioned \		Jornan
٤		on Strip in	lube	-	Cut Too Short Drill Holes	<b>—</b>	read		L	Power Loss,	'Surge	Other
}	<b>⊣</b> '' :	· · · · · · · · · · · · · · · · · · ·				Offs		althoration				
}				¹	Drawing	<b>⊢</b>		alibration				
}		Turning Sequence Finish				_		equence			·	
1	Wave/Tr	vist in Tube Folio					tside	Dimensions				

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Tuesday, March				*980	).31*	•					Page 2
Item ID:	D2221			Accept	*N900	040	100	)*	Setup Sta	rt *N	S1*
Revision ID:									Sto	n 4-14 n	004
Item Name:	350 Basket Ba	ase							500	<sup>ν</sup> ^Ν	<b>IS2</b> *
Start Date:	3/4/2013	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	4/9/2013	Req'd Qty: 1.00	*1*		Customer:				,		
Reference:			•						- 6.		
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:			Run Sta	"17	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	» *N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC6- Inspect dimension	s to drawing	0.00							MAn
*120* QC Quality Control		Memo		0.00				· · · · ·	13 <u>-03-3</u>	NE	DAS 0.99
125		Pressure Wash per QSI0	05 4.3	0.00				, (	Vi	سر د ر	
*105* HandFinish		Memo		0.00				1 A	73.3	-25	+

Hand Finishing

NCR: Y	'es / No				WORK ORDER NON-O	CONFC	RMANCE / L	JPDATE			
									QA Closed:	Date:	
Work Orde	ır.				DISPOSITION			AGAINST D	DEPARTMENT	/PROCESS	
		1			Rework	7	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.	ĺ			Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	<u> </u>	i			Use-as-is	Th	ermoforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	]	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initia	1	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng De	escription	Date	Verification	QC Inspector
Doc/Data								_			
quip/Tooling	-										
Operator	_	1 .									
Material	_					Ì					
Setup											
Other											
Process	_										
Supplier	_										·
Training Jnapproved		<b>'</b>									
oughbiosed T	<u></u>		1	1	F	AULT CA	TEGORY			<u> </u>	
Landir	ng Gear			<del></del>	General				· · · · · · · · · · · · · · · · · · ·		
	Bending				Bend	Gra	in		Ovalized		Pressure/Forced
1	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hard	lware	T	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete	e [	Part Incorre	ect	Weld
	Crushed/	/Crimped			Burrs	Inst	uctions Incomple	te/Unclear	Part Lost/M	lissing	Wrong Stock Pulled
	Cuffs	Cuffs Contamination				Ma	ntenance		Part Moved		
	Heat Tre	Heat Treat Countersink				Mis	abeled		Positioned \	Wrong	<b>-</b>
	Inspection	n Strip in	Tube		Cut Too Short	Miss	ead	Ĺ	Power Loss,	/Surge	Other
	Ripples				Drill Holes	Offs					
	Torque Waves in Extrusion			n	Drawing	<b></b>	of Calibration				
·	Turning Sequence				Finish	Out	of Sequence				

Outside Dimensions

DQA:

Date:

Wave/†wist in Tube

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Work Orde Tuesday, March				*980	)31*				Page 3
Item ID: Revision ID: Item Name:	D2221 350 Basket B	ase		Accept	*N9000	40100	<b>)*</b> Se	tup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	3/4/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				14.32
Approvals:	Process Pla	an:	Date:		Date:	:	Ru	n Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating		2ND COAT START TIM OVEN TEM	AE:  APERATURE:  AE:  AE:  AE:  AE:  AE:  AE:  AE:	Set Up/ Run Hours 0.00 0.00 400 400 necessary***********************************		Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
*140 *140*		QC3- Inspect Part Finish	ı,	0.00		·	<i>i</i> 4	b <u>/</u> 3	8-26. no

Memo

Quality Control

		į								DQA:	Date:	<b>∮</b> 0.7=0 <b>↓</b>
NCR: Y	es / No	ı			WORK ORDER NON-C	CON	IFORM	MANCE / UP	DATE			***
										QA Closed:	Date:	·
Work Orde	~~.				DISPOSITION	ł			AGAINST DE	PARTMENT	/PROCESS	
Work Orde	٥١. 				Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	١n				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, arer	···	i			Use-as-is	1		noforming	Finishing	ł	re/Packaging	Other
NCR N	No.	i			Work Order Update	1 1		Large Fab	Composite		Supplier	
									·		· ·	
Root					ption of work order update	1	nitial	Act		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup		j <b>i</b>										
Other												
Process								·				
Supplier										:		
Training												
Unapproved		1	<u> </u>	L	F	<u>ι</u> Διμη	T CATE	L GORY			<u> </u>	<u>.</u>
Landii	ng Gear				General	702	·	<u> </u>		****		
	Bending			<u> </u>	Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	$\vdash$	Hardwa	re	<b> </b>	Over/Under	tolerance	Temperature/Cure
	Cracks		·		Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
ء جور کج	Crushed/	Crimped.	-		Burrs	$\vdash$		ions Incomplete/L	Inclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs	•		<u> </u>	Contamination	_	Mainte			Part Moved	<del></del>	<b>-</b>
. 0	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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Work Orde Tuesday, March				*980	)31*							Page 4
Item ID: Revision ID:	D2221			Accept	*N900	<b>040</b>	100	)*	Setup	Start	1 7	S1*
Item Name:	350 Basket Ba	ase								Stop	*N	S2*
	quired Date: 4/9/2013 Req'd Qty: 1.00		*1* *1*		Cust Item I Customer:	D:					•	
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	*N *N	R1*
Sequence ID/ Work Center II  150  *150* Packaging Packaging		Operation Description Identify as per dwg & Ste	ock Location D350	Set Up/ Run Hours	Tool ID 9 <i>86</i> 66,	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160 *160* QC Quality Control	•	QC21- Final Inspection -	Work Order Release	0.00						13/4	1/3°	NF 760

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	AANCE / UP	DATE			
											QA Closed:	Date	2:
Work Orde			1			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	٠.		<u>:</u>	<del></del>		Rework	1	l	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	Vo.		i			Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	••••		ļ			Use-as-is	1		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o.					Work Order Update	]		Large Fab	Composite	]	Supplier	
				1	D		<u> </u>	Initial	Λ.	tion	Sign 9	<u> </u>	
Root		D-4-	Cham			ption of work order update or Non-conformance		nief Eng		ription	Sign & Date	Verification	QC Inspector
Cause	$\vdash$	Date	Step	Qty		or Non-comormance		ilei Eilg	Desc	прион	Date	Vermeation	QC IIIspector
Doc/Data	Н	İ	:										
Equip/Tooling	Н	i	-								į		
Operator Material	$\vdash \vdash \vdash$		<u> </u>										
Setup	$\vdash$	!	<b>!</b>										
Other	H	İ											
Process	$\vdash \dashv$	i									1		
Supplier	H	!											
Training													
Unapproved			İ				<u> </u>						
						F	AUL	T CATE	GORY	· · · · · · · · · · · · · · · · · · ·			
Landi	ng G	iear				General		-			7	_	_
	Bending					Bend		Grain		_	Ovalized	-	Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	<u> </u>	Hardwa			Over/Unde		Temperature/Cure
	Cracks					Broken/Damaged	_	<b>-</b> 1	on Incomplete	_	Part Incorre	<b>⊢</b>	Weld
Crushed/Crimped					<u> </u>	Burrs	$\vdash$	4	ions Incomplete/	'Unclear	Part Lost/N		Wrong Stock Pulled
	Cuffs					Contamination		Mainte		<u> </u>	Part Moved		
		Heat Trea			<u> </u> _	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned '		¬
i	Ш	Inspection	n Strip in	Tube		Cut Too Short		Misread	ı	L	Power Loss	/Surge	Other
l .	1	Dinnles in	Dond										

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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## · Picklist Print

Tuesday, March 05, 2013 1:38:15 PM

Work Order ID: 98031

\*98031\*

Parent Item:

D2221

\*D2221\*

Parent Item Name: 350 Basket Base

**Start Date:** 3/4/2013

Required Date: 4/9/2013

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM

IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC

IPP Rev:L 08-09-24

plug holes prior to powder coat DD verified by:EC IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC

IPP Rev:N

10.06.29 added pressure wash DD verf:EC

		ssure wash DD v											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1	4911-491-1-1-1	Manufactured	No			100	Each	12.0000	1	1			
*D2221-1*									**		156 <del>3</del>		
				Location	<u>!</u>	Loc	<u>Oty</u>	Loc Code		Si	113.03	3.19	
				WA005			12				_		
					86847		1						
					86848		1		_		<del></del>		
					90856		10				_		
02221-5		Manufactured	No			100	Each	7.0000	2	2			
*D2221-5*									**	B 94	1273 LJ/	-> 2,	/
XIO				Location	ı. L	Loc	<u>Oty</u>	Loc Code			AS 1	3.03	3.19
				WA004			5		<u></u>		_		
					90840		5		_				
				WA006			2				_		
					67117		2		-		<b></b>		
D2221-7		Manufactured	No			100	Each	5.0000	1	1			
*D2221-7*									** -	B 8°	7715		
				Location	<u>l</u>	<u>Loc</u>	<u>Oty</u>	Loc Code		_	ld 13	.03.1	9
				WA004			5				_		
					89398		5						

NCR:	Yes	/ No				WORK ORDER NON-C	ON	NFORI	MANCE / UPI	DATE	QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·
Work Ord	er.			-		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	No					Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Ť		_		Descri	tion of work order update	1	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		,	step Qty of										
						F	AUL	T CATE	GORY				
Landi	ing Gear  Bending  Centre Not Concentric to O/S  Cracks  Crushed/Crimped  Cuffs  Heat Treat  Inspection Strip in Tube  Ripples in Bend  Torque Waves in Extrusion  Turning Sequence			Tube	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete ions Incomplete/U enance eled d	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	7	Turning Sequence Finish						Out of S	Sequence				

Outside Dimensions

DQA: Date:

Wave/Twist in Tube

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Location	Loc Qty	Loc Code	S
WA004	48		
70766	2		
81253	1		
82506	2		
83230	3		
85452	2		
87706	2		
92871	10		
94204	26		

			1									DQA:_	Date	e:	178	
NCR:	Yes	/ No				WORK ORDER NON-C	10:	NFORI	MANCE / UP	DATE	Ο Δ	Clasadi	Date	o ·	1.4	
											ŲΑ	Closed:	Date	۲.		_
and a cond			1			DISPOSITION				AGAINST DE	PAR	TMENT/	PROCESS			
Work Ord	er: .					Rework			Skid-tube	Crosstube	1		Water Jet	$\neg$	Engineering	
Part I	Na		İ			Scrap			Machining	Small Fab		Prod	I. Eng. Coor.	-	Quality	
raiti	NO.	<del> </del>	<del> </del>			Use-as-is			noforming	Finishing	 		e/Packaging	$\dashv$	Other	١
NCR I	No.		İ			Work Order Update			Large Fab	Composite	1	,	Supplier	7	i	
			1	-	<del></del>		1		ů L	٠ ــــــ						
Root					Descri	ption of work order update	ı	nitial	Ac	ction	Şi	ign &				
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription	1	Date	Verification		QC Inspector	
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Equip/Tooling															1	
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Process	Ш	,									]	l			i	
Supplier											}	Ì			\$	
Training	Ш											ĺ			į	
Unapproved		i		L			<u> </u>				<u> </u>				· /	
				<del></del>			AUL	T CATE	GURY							
Landi	$\overline{}$	1			F	General	_	Grain			10	ilized	· г	٦,	ressure/Forced	2
	Bending Control Not Conservation to O/S					Bend BOM/Route	-	Hardwa	r0	<del> </del>	4	inzeu er/Under 1	toloranco		emperature/Cure	٠ د
	Centre Not Concentric to O/S				<sup>0/3</sup>  -	4 · · · · · · · · · · · · · · · · · · ·	$\vdash$	4		<del> </del>	-1	t Incorrec	-	_	veld	•
	-	Cracks Crushed/	Crimnad		-	Broken/Damaged	$\vdash$	1	on Incomplete ions Incomplete,	/Unclear	-1	t Lost/Mis		—	veid Vrong Stock Pulle	٠Ч ,
	_	Crusneay Cuffs	crimpea.		-	Burrs Contamination	-	Mainte	-	Officieal	┥	t Moved	231118	<sup>v</sup>	Frong Stock Fulle	u
	<b>⊢</b> ⊸	Heat Trea	·+		-	Countersink	$\vdash$	Mislabe		<u> </u>	-	itioned W	/rong			
	$\vdash$	Inspectio		Tuhe	-	Cut Too Short	$\vdash$	Misreac		<u> </u>	-	ver Loss/S			ther	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

6

WA005

90866

95286

NCR:	Yes / No				WORK ORDER NON-O	CON	NFORN	MANCE / UPD	ATE			
										QA Closed:	Date:	
Work Ord	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	1
Work Ora		<del></del>	<u> </u>		Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering
Part i	No				Scrap		ľ	Machining	Small Fab	4	d. Eng. Coor.	Quality
					Use-as-is			oforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No			<del></del>	Work Order Update	J		Large Fab	Composite	J	Supplier	
Root				Descri	ption of work order update	1	nitial	Actio	on	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			1									
Operator												
Material	_		1 1								:	
Setup												
Other												1
Process												:
Supplier	-	1										!
Training												
Unapproved		1	11		F	AUL	T CATE	GORY				<u>:</u> .
Landi	ng Gear	!			General							
	Bending	;			Bend		Grain			Ovalized		Pressure/Forced
Centre Not Concentric to O/S					BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/Crimped_				Burrs		Instruct	ons Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	1			Contamination		Mainte	nance	ļ	Part Moved		
	Heat Tr	eat			Countersink		Mislabe	led		Positioned V		<b>,</b>
	Inspecti	on Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes		Offset					1
	Torque	Waves in I	Extrusion	, [	Drawing		Out of C	Calibration				i

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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Pickist Print Tuesday, March 05, 2013 1:38:15 PM	1					Page 4		
Work Order ID: 98031		*98031*						
Parent Item: D2221		*D2221*						
Parent Item Name: 350 Basket Base		177771			Start Date: 3/4/2013 Start Qty: 1.00	Required Date: 4/9/2013 Required Qty: 1.00		
D3832-1	Manufactured	No	100 Eacl	h 5.0000	1 1			
*D3832-1* Mesh (Base)					** B8	37144 M13.03.		
		<b>Location</b>	Loc Qty	Loc Code	<b>:</b>			
		WA	4			<u> </u>		
		96614	4					
		WA007	1			<u> </u>		
D3833-1	Manufaatawad	85951 No	l 100 Eacl	h 14.0000	2 2			
*D3833-1* Mesh (Base End Face)	Manufactured	140	100 Eac.	14.0000	**	13-3-71		
		Location	Loc Oty	O no Loc Code		<b>)</b>		
		WA007 77521	14	15 48096 —		<u>7</u>		

81259 89208 92602

NCR: Y	es / No	! 			WORK ORDER NON-	COIN	NFURI	VIAINCE / UP		QA Closed:	Dat	e:	
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Work Orac					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.				Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1	Thermoforming Finishing			Rec/Stor	e/Packaging	Other	
NCR N	lo				Work Order Update	]		Large Fab Composite			Supplier		
Root				Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data													
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<del></del>					F	AUL	T CATE	GORY					
Landir	ng Gear				General	_				•		····	
	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced	
	Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks	Broken/Damaged			Broken/Damaged	Ш	Inspect	ion Incomplete		Part Incorre	ct	Weld	
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	Ш	Mainte	enance		Part Moved			
[	Heat Tre	at			Countersink		Mislabe	eled		Positioned V	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other	
	Ripples i	n Bend			Drill Holes		Offset						
	Torque V	Vaves in E	xtrusio	n [	Drawing		Out of (	Calibration					
	Turning	Sequence			Finish		Out of 9	Sequence					
	Wave/Tv	ave/Twist in Tube Folio					Outside Dimensions						

DQA: \_\_\_\_Date: \_\_\_\_\_\_

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ITEM QTY P/N DESCRIPTION D2221 BASKET BASE ASSEMBLY (AS350) D2221-1 RIB 2 D2221-5 RIB D2221-7 RIB BASKET HINGE 2 D2232-3 D D D2235-1 RIB 6 2 MOUNTING BRACKET D2581 2 8 2 D3442-1 SHIM 9 D3825-041 RIB ASSY (BASKET END) 10 2 D3826-041 RIB/GUSSET ASSY 11 D3827-041 RIB ASSY (INBOARD) 12 2 D3833-1 MESH, BASE END FACE 13 D3832-1 1 MESH (BASE) 9 (13) (13.03.5)
RE-/11/15/15/15 D2221 BASKET BASE ASSEMBLY (AS350) (MESH SHOWN LOCALLY FOR CLARITY) REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A. B-B AND C-C (ZN C6-3). C2-3 AND A6-3); REVISED SECTIONS A-A. B-B AND C-C (ZN C6-3). C2-3 AND A6-3); REVISED DETAIL (ZN D24); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAIL S FOR D222-1-1-5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D325-9-41 REPLACES D221-3/02327-3 D326-041 REPLACES D221-10/3237-3 D326-041 REPLACES D223-1 (D018); ADDED D3352-1 AND D3333-1, REASON: SATISFY "LEAN MANUFACTURING" PROGRAM. 08.09.18 MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL:
TOLERANCE FOR 96.00 DIM WAS +4-0.01 AND 56.00 DIM
WAS REF (2M 58-2); 19.62 DIM WAS "HARD" DIMENSION IS
NOW "REF" (2N 94-2); NOTE 5 TRANSFERED FROM SHT 1
TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING
TRANSFERED TO "B" FORMAT AJS 08.06.16 ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET PH 05.06.07 E CHANGE HINGE CP 01.04.19 ٥ CHANGE LATCH BW 96.06.21 С SEPARATE BASKET AND LID 95.11.21 REV. BY DATE DESIGN DART AEROSPACE LTD DRAWN 1) MATERIAL: N/A HAWKESBURY, ONTARIO, CANADA 1) MATERIAL MA 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED DRAWING NO. CHECKED REV. H D2221 MFG. APPR SHEET 1 OF 5 APPROVED BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A BASKET BASE ASSEMBLY (350) NTS DE APPR. 8) WEIGHT: 42.00 lbs APPROX COPYRIGHT © 1994 BY DART AEROSPACE LTD DATE 08.09.18 9) MASK ALL HOLES PRIOR TO POWDER COATING 6 3

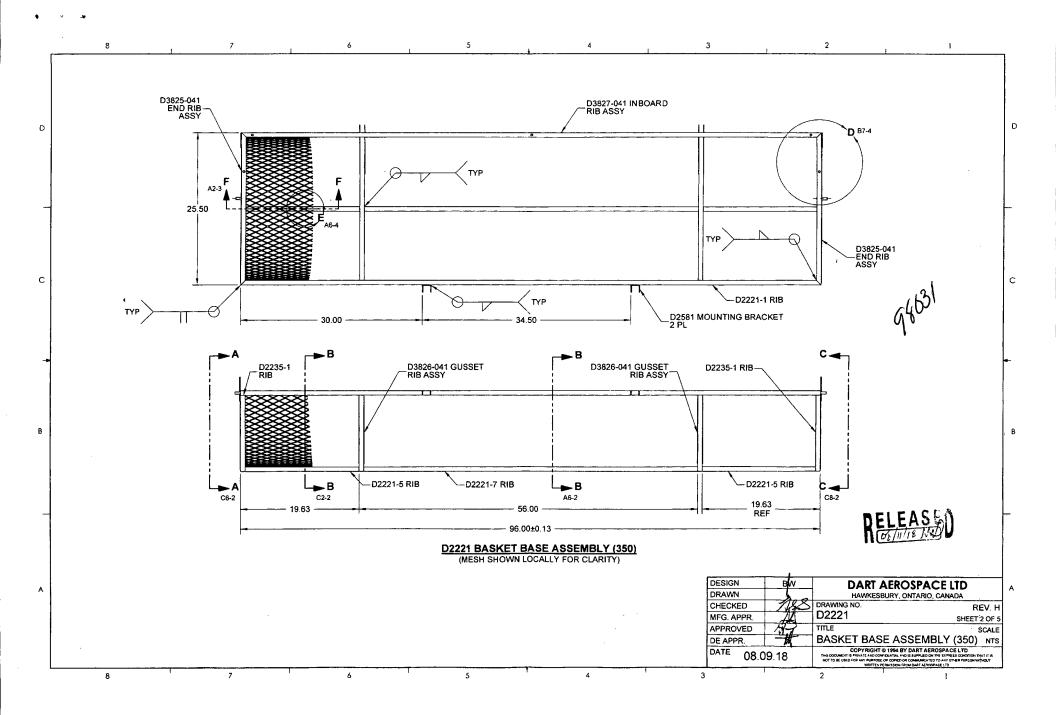
NCR:	Yes / No	Ī			WORK ORDER NON-O	CONF	ORN	VIANCE / UP	DATE	QA Closed:	Date	:	
Work Ord	or:	į.		***	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
					Rework	]	Skid-tube Crosstube			,	Engineering Quality	]	
Part I	No	1			Scrap	┥╽.		Machining	Small Fab	4	d. Eng. Coor. re/Packaging	Other	+
NCR I	No	i			Use-as-is Work Order Update		Thermoforming Finishing Rec/Store/P  Large Fab Composite				Supplier	J	
Root				Descri	ption of work order update	Ini	tial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspecto	r
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				-		AULT	CATE	GURY					
Landi	ing Gear	i i			General Bend	Пс	rain			Ovalized		Pressure/Forced	
	Bending	1	-+-:-+-	0/s	BOM/Route	$\vdash$	ardwa	ro		Over/Under	tolerance	Temperature/Cur	۰.
	Cracks	entre Not Concentric to O/S			Broken/Damaged	<b>—</b>		on Incomplete	-	Part Incorre	<del>-</del>	Weld	
	$\vdash$	/Crimped		-	Burrs	$\vdash$		ions Incomplete/	Unclear	Part Lost/M	<del> </del>	Wrong Stock Pull	ed
	Cuffs	Cumben	•	-	Contamination	_		nance	- Cricieai	Part Moved	· ·		cu
	Heat Tre	 at		<u> </u>	Countersink	$\vdash$	1islabe			Positioned V			
	$\vdash$	n Strip in	Tube	, <b> </b>	Cut Too Short	$\vdash$	1isreac			Power Loss/		Other	
	Ripples i		TUDE	·	Drill Holes	$\vdash$	ffset	-	<u>l</u>	٦. ٥٠٠٥، ١٥٥٥/		1	
	<b>—</b>		Extrusio	,	Drawing	$\vdash$		Calibration		<del></del>			
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Outside Dimensions

DQA: \_\_\_\_\_ Date: \_\_\_\_\_,

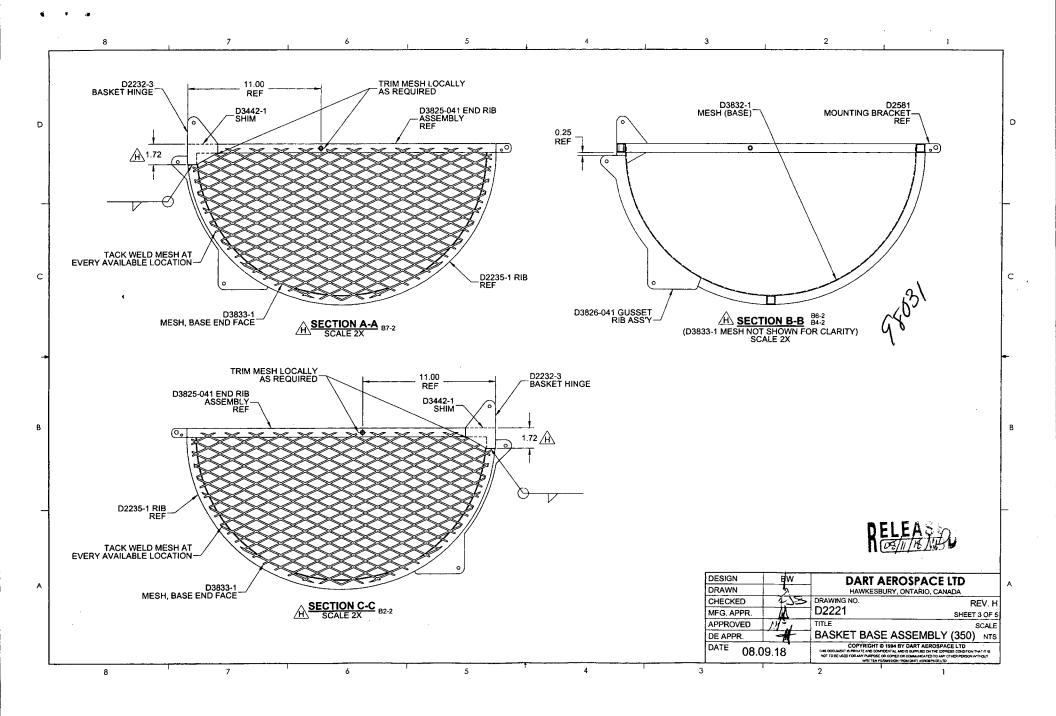
Wave/Twist in Tube

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										DQA:	Date	): 			
NCR: \	es .	/ No				WORK ORDER NON-O	CONFOR	MANCE / UPE	DATE						
										QA Closed:	Date	2:			
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	art No.					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality			
NCR N	NCR No.					Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			~ <u></u>	Rec/Store/Packaging Other Supplier					
Root					Descri	ption of work order update	Initial	Act	ion	Sign &					
Cause		Date	Step	Qty	(	or Non-conformance	Chief En	g Descr	iption	Date	Verification	QC Inspector			
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L						F	AULT CAT	EGORY							
Landir	ng Ge	ar				General				<del>-</del>	_	_			
	В	ending				Bend	Grain			Ovalized	L	Pressure/Forced			
	c	entre No	t Concer	ntric to	o/s	BOM/Route	Hardw	are	<u></u>	Over/Under	tolerance	Temperature/Cure			
	c	racks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct L	Weld			
	c	rushed/C	rimped.			Burrs	Instruc	ctions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	c	uffs				Contamination	Maint	enance		Part Moved					
	Н	eat Treat	t			Countersink	Mislab	eled		Positioned V	Vrong _	_			
	lr	nspection	Strip in	Tube		Cut Too Short	Misrea	nd		Power Loss/	Surge	Other			
` [	R	ipples in	Bend			Drill Holes	Offset								
	T	orque Wa	aves in E	xtrusio	n 🗌	Drawing	Out of	Calibration							
	]T	urning \$e	equence			Finish	Out of	Sequence							
		Jave/Twi	st in Tub	10		Folio	Outside Dimensions								

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NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
		1								QA Closed:	Date:			
er: _					DISPOSITION	, 	AGAINST DEPARTMENT/PROCESS  Skid-tube Crosstube Water Jet Engineering							
Part No					Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing Large Fab Composite			-1	d. Eng. Coor.	Quality Other			
	Date	Step	Qty		•	1				Sign & Date	Verification	QC Inspector		
												·		
					F	AUL	T CATE	GORY						
	Bending   Centre No Cracks Crushed/C Cuffs   Heat Trea Inspection	Crimped et n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/U nance led	Jnclear	Part Incorre Part Lost/M Part Moved Positioned V	ct sissing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
	er: _	Date  Date  Date  Date  Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in	Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step  Date Step	Date Step Qty  Date Step Qty  Date Step Qty  Date Step Qty  Control Date Step Qty  Date Step Qty  Date Step Qty  Date Step Qty  Date Step Qty  Date Step Qty  Date Step Qty	Date Step Qty  Date Step Qty  Description  D	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Bending Gear General Bend BoM/Route Broken/Damaged Burrs Cushed/Crimped.  Cracks Broken/Damaged Burrs  Cuffs Burrs Contamination  Cuffs Contamination  Heat Treat Countersink  Inspection Strip in Tube Ripples in Bend Drill Holes	Pr: Brish Bend Bend Bend Bend Bend Bend Bend Bend	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Bending Centre Not Concentric to O/S BOM/Route Broken/Damaged Inspection Cracks Crushed/Crimped Cutfs Contamination Mainted Cutfs Countersink Mislabed Ripples in Bend Drill Holes  DISPOSITION  Rework Scrap Use-as-is Work Order update or Non-conformance  Initial Chief Eng  FAULT CATE  General  Bend Grain Hardwa Inspection Strip in Tube Countersink Mislabed Ripples in Bend Offset	DISPOSITION  Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Large Fab Use-as-is Step Qty Or Non-conformance Chief Eng Description of work order update Chief Eng Description of Work Order Update Use-as-is	DISPOSITION  Rework Scrap Use-as-is Work Order Update Use-as-is Us	AGAINST DEPARTMENT,  Rework Scrap Use-as-is Work Order Update Or Non-conformance Or Non-conformance Or Non-conformance Or Sign & Description Of Work Order Update Or Non-conformance Or	DISPOSITION   AGAINST DEPARTMENT/PROCESS     DISPOSITION   AGAINST DEPARTMENT/PROCESS   Water Jet     Disposition   Skid-tube   Machining   Small Fab   Prod. Eng. Coor.     Thermoforming   Finishing   Rec/Store/Packaging     Large Fab   Composite   Supplier     Date   Step   Qty   Description of work order update   Initial   Action   Date   Verification     Date   Step   Qty   Or Non-conformance   Chief Eng   Description   Date   Verification     Date   Step   Qty   Or Non-conformance   Grain   Ovalized     Chief Eng   Description   Ovalized   Over/Under tolerance     Centre Not Concentric to O/S   BoM/Route   Hardware   Inspection Incomplete   Part Incorrect     Crushed/Crimped   Burrs   Instructions Incomplete/Unclear   Part Lost/Missing     Cuffs   Contamination   Maintenance   Part Moved     Heat Treat   Countersink   Mislabeled   Positioned Wrong     Ripples in Bend   Drill Holes   Offset   Offset     Drill Holes   Offset   Offset   Offset		

Out of Sequence

Outside Dimensions

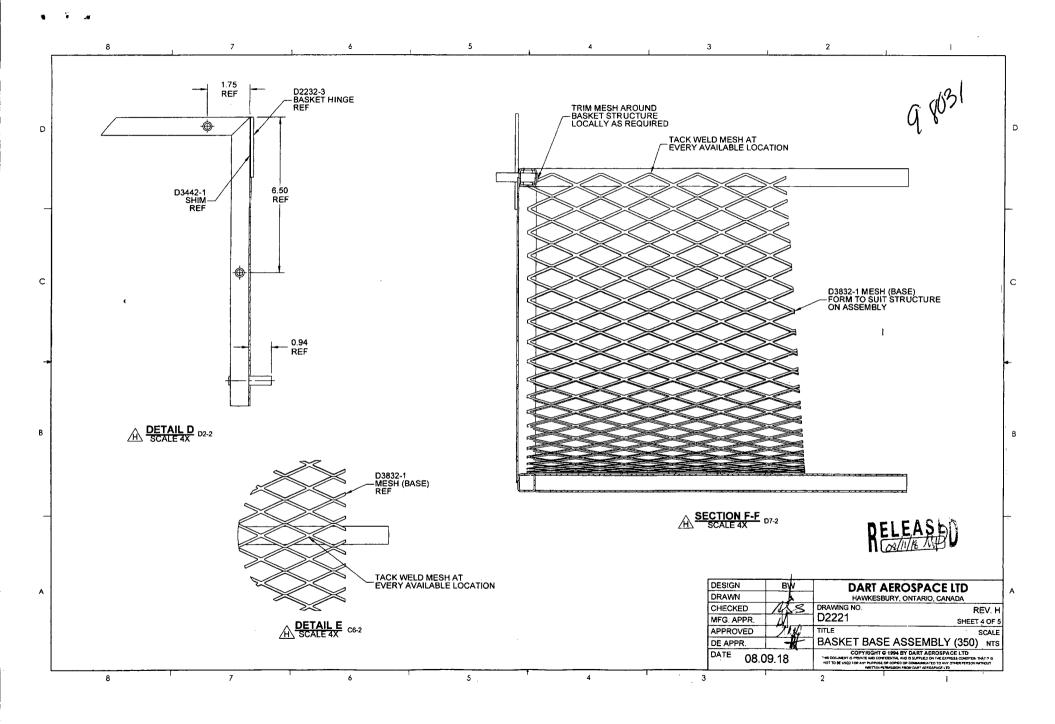
DQA: Date:

Turning|Sequence

Wave/Twist in Tube

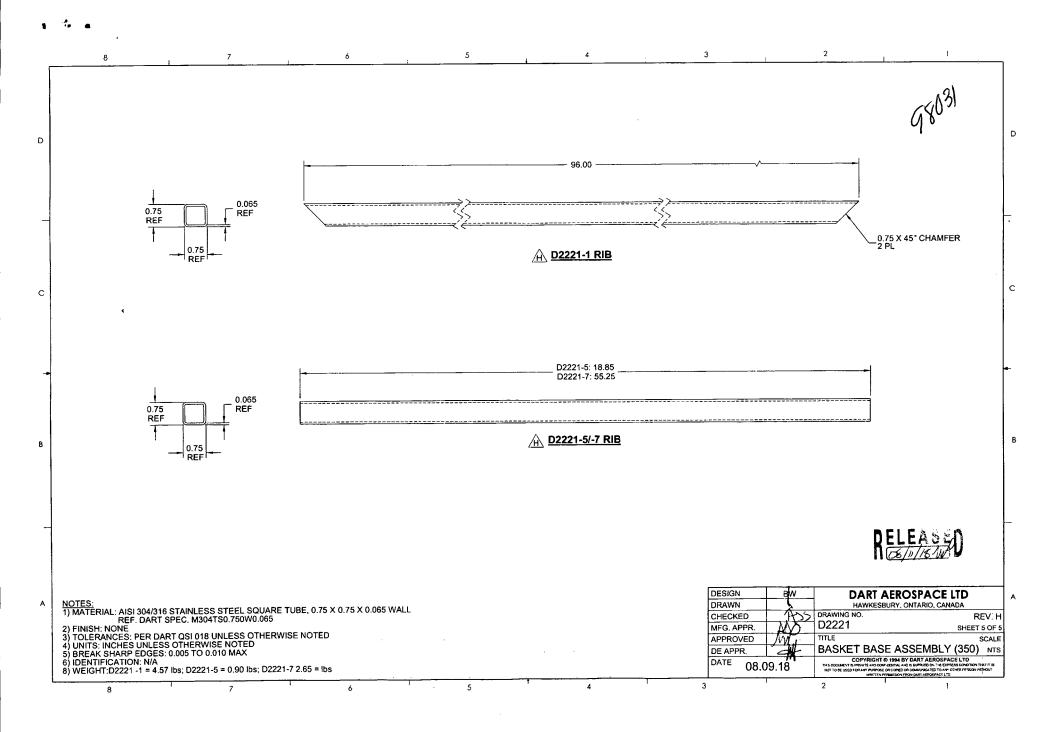
Finish

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											DQA:	Dat	e:	
NCR:	Yes /	No	1			WORK ORDER NON-O	CON	IFOR!	MANCE / UPI	DATE	OA Classed	Dat		
			<del>- </del>			I	Т				QA Closed:	Dat	.e.	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS		
Work Orac	-'' —		<del>i</del>			Rework	1		Skid-tube	Crosstube	Water Jet			Engineering
Part N	No.		1			Scrap	1		Machining	Small Fab	Prod	d. Eng. Coor.		Quality
			1			Use-as-is	]		noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR No.			<u>.</u>	Work Order Update	]		Large Fab	Composite		Supplier				
Root		-			Descri	ption of work order update	Ir	nitial	Act	tion	Sign &	•		
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	1	QC Inspector
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	$\blacksquare$	acks	Broken/Damaged				$\vdash$	•	ion Incomplete		Part Incorrect Weld			
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	— 1	ıffs				Contamination	$\vdash$	Mainte		ļ	Part Moved			
	<b>⊢</b>	Heat Treat Countersink Inspection Strip in Tube Cut Too Short				<del>-1</del>	-	Mislabe		<u> </u>	Positioned V			
	_			Tube	$\vdash$	Cut Too Short	$\vdash$	Misread	i .	<u>L</u>	Power Loss/	Surge	Lo	ther
	$\vdash$	pples in			<u> </u>	Drill Holes		Offset			****			
	$\blacksquare$	, (	aves in E		n	Drawing	Out of Calibration							
	$\blacksquare$	- 1	equence		<u> </u>	Finish	Out of Sequence							
	W	ave/Twi	ist in Tub	oe -		Folio	Outside Dimensions							

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									DQA:	Date:				
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UPE	DATE	QA Closed:	Date:				
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS				
Part N	0.				Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite				Water Jet Engineerin Prod. Eng. Coor. Qualit Rec/Store/Packaging Othe Supplier					
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initial Chief En	<u> </u>		Sign & Date	Verification	QC Inspector			
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved														
	i				F	<b>AULT CAT</b>	EGORY							
Landin	Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped.			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence			Ovalized Pressure/Ford Over/Under tolerance Temperature Part Incorrect Weld Part Lost/Missing Wrong Stock Part Moved Positioned Wrong Power Loss/Surge Other					
·	Wave/Tw				Folio	$\blacksquare$	Outside Dimensions							

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